

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011062**Date Inspected:** 03-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Qi Guo, Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER / OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Cored Arc Welding process for weld SSD1-SA15D/F-09 located on PCMK the weld between P170 and P786 on skin A of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053116 performing Flux Cored Arc Welding process for weld SSD1-SA18-24 located on PCMK the weld between P169 and P1144 on skin B of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc

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Welding process for weld SSD1-SA17F/G-55 located on PCMK the weld between P179 and P1144 on skin C of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for weld SSD1-SA17F/G-53 located on PCMK the weld between P179 and P1144 on skin C of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200676 performing Flux Cored Arc Welding process for weld OBW 6C-001 located on PCMK side panel splice weld between OBG segment 6BW and 6CW (cross beam side). ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for weld OBW 6C-002 located on PCMK side panel splice weld between OBG segment 6BW and 6CW (cross beam side). ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for weld OBW 6C-003 located on PCMK bottom panel splice weld between OBG segment 6BW and 6CW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for weld OBW 6A-003 located on PCMK deck panel splice weld between OBG segment 6BW and 6CW. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223 (2) 1-T-2.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer